

Date: Thursday, 07/08/2008 4:23:24 PM
 User: Julie Lecocq

Process Sheet

SPLIT-1

| | | | |
|-----------------------|---|------------------|---------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ARM |
| Job Number | : 41068 | | |
| Estimate Number | : 12883 | | |
| P.O. Number | : | Part Number | : D3560043 |
| This Issue | : 07/08/2008 S.O. No. : | Drawing Number | : D3560 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : D |
| Previous Run | : 40300 | Material | : |
| Written By | : | Due Date | : 26/08/2008 Qty: 3 Um: 10 Each |
| Checked & Approved By | : JLP 08.8.08 | | |
| Comment | : Est Rev:A New Issue 07.05.24 EC | | |
| | Est Rev B ECN 987 07.10.09 EC | | |
| | Est Rev:C ECN1048 07-12-18 DD verified by: EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0500X05000 | 6061-T6 Bar .500 x 5.00 |
|-----|--------------------|-------------------------|



Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: W108854

JL 08/08/24

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW

Cut blanks 15.500" long

JL 08/08/24

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

DTP 08/08/26

(12)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 08/08/27

(12)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 07/08/2008 4:23:24 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 08/09/02 (42)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE

B 41083 ✓

SP

08.09.09

(3X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch (65 deg C) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

08.09.09

(3X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/09/02 (43)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-09 (3)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-p 08/09/11

(3X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/09/11 (3)

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

batch:

637113

EP 08/09/11

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

EP 08/09/11 (3)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soe 08/09/11 (x3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

132

08/09/12

(x3)

50

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



MF 08-09-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | | | |
|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 41068 |
| Description: Arm | | Part Number: | D3560-3 |
| Inspection Dwg: D3560 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

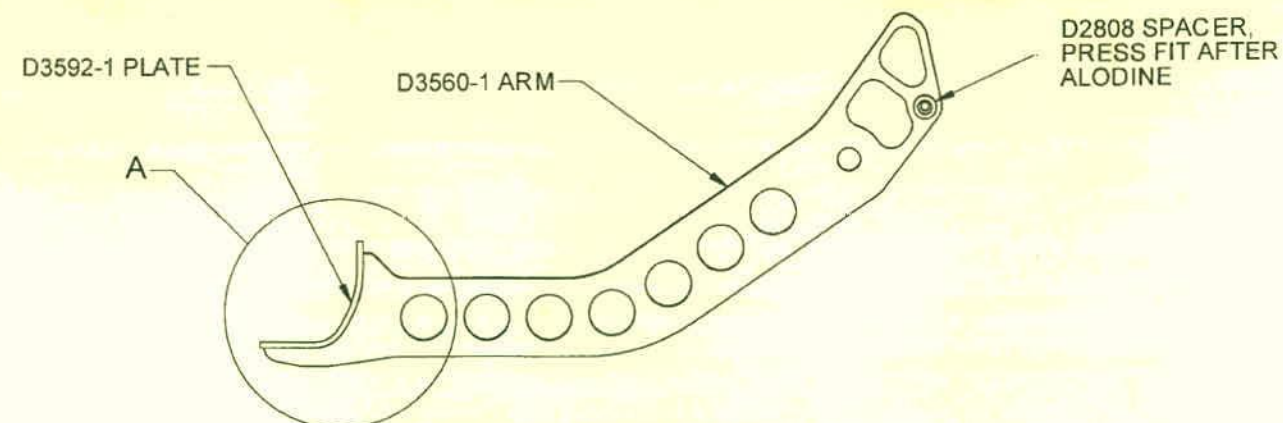
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| Ø0.507 | +0.000/-0.001 | 0.5065 | ✓ | | | |
| Ø0.196 | +0.005/-0.001 | 0.198 | ✓ | | | |
| Ø1.000 | +0.010/-0.001 | 1.005 | ✓ | | | |
| Ø0.900 | +0.010/-0.001 | 0.903 | ✓ | | | |
| 0.500 | +/-0.010 | 0.503 | ✓ | | | |
| 0.250 | +/-0.010 | 0.248 | ✓ | | | |
| 0.275 | +/-0.010 | 0.270 | ✓ | | | |
| 0.188 | +/-0.010 | 0.184 | ✓ | | | |
| 2.000 | +/-0.010 | 2.005 | ✓ | | | |
| 1.750 | +/-0.010 | 1.752 | ✓ | | | |
| 1.702 | +/-0.010 | 1.707 | ✓ | | | |
| Ø0.385 x 100° | +/-0.010 x 0.5° | Ø0.380 x 100° | ✓ | | | |
| 0.250 Deep | +/-0.010 | 0.258 | ✓ | | | |
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|------------------|----------------|---------------------|-----|
| Measured by: DIP | Audited by: SA | Prototype Approval: | N/A |
| Date: 08/08/26 | Date: 08/07/02 | Date: | N/A |

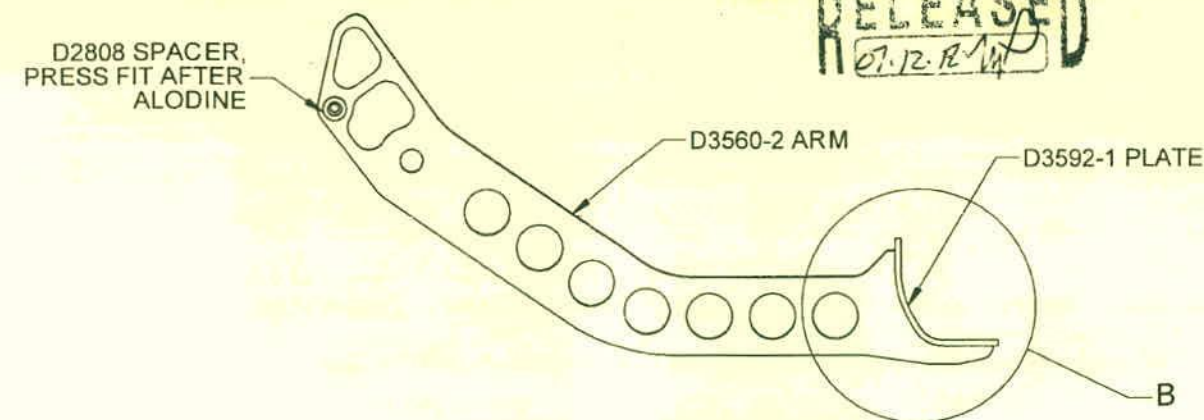
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 07.01.17 | New Issue | KJ/JLM | |
| B | 07.06.13 | Dimensions updated per Dwg Rev B | KJ/JLM | EA |



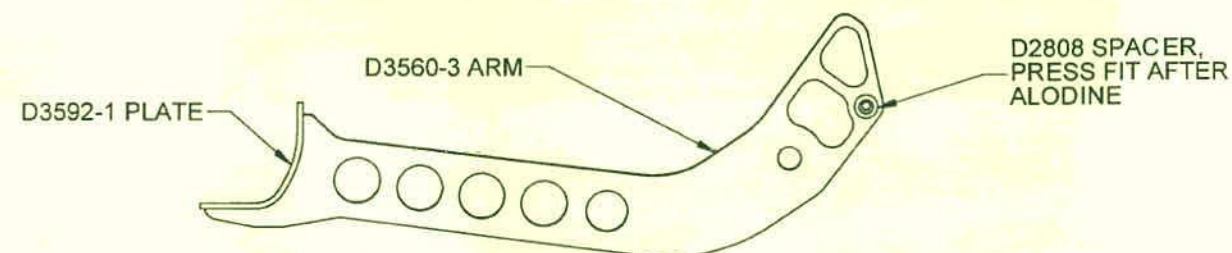
RELEASED
07.12.16



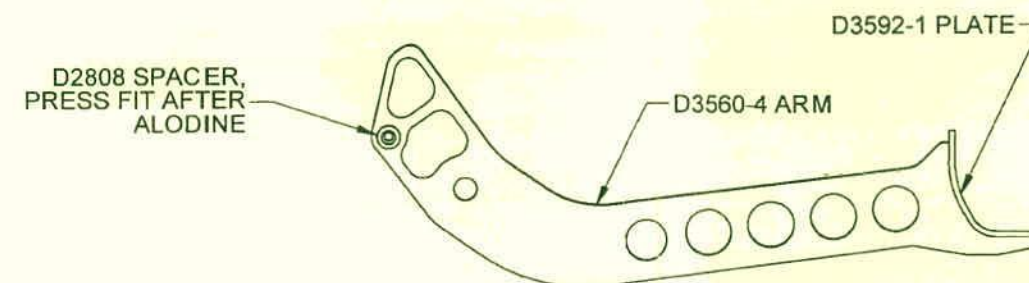
D3560-041 ARM WELDMENT



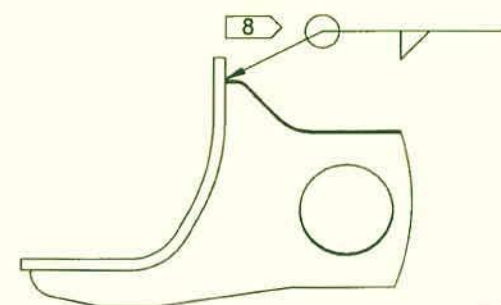
D3560-042 ARM WELDMENT



D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



DETAIL A
SCALE 1:2

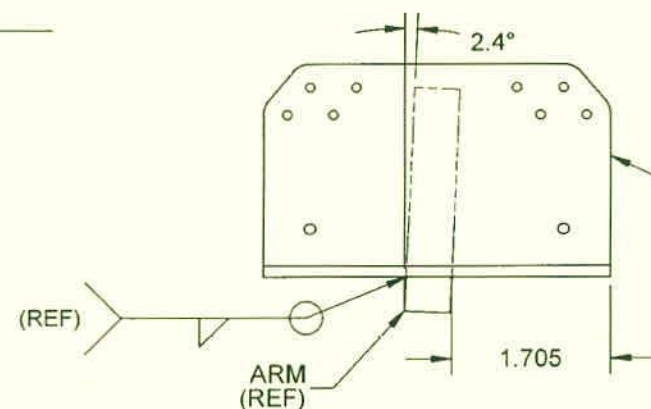
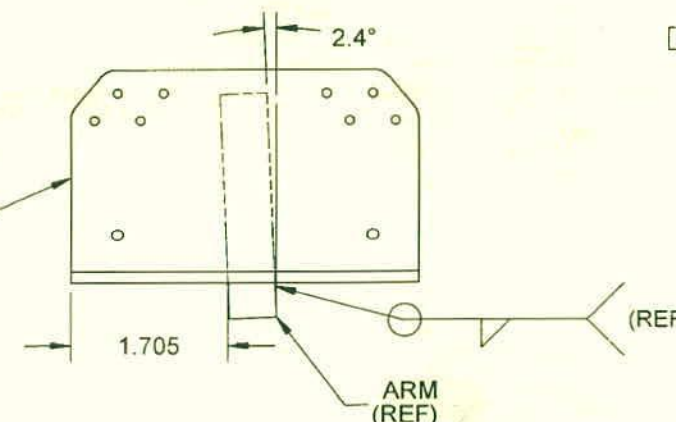


PLATE
(REF)



DETAIL B
SCALE 1:2

PARTS LIST

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | P/N | DESCRIPTION |
|-------------|-------------|-------------|-------------|-----------|--------------|
| X | | | | D3560-041 | ARM WELDMENT |
| | X | | | D3560-042 | ARM WELDMENT |
| | | X | | D3560-043 | ARM WELDMENT |
| | | | X | D3560-044 | ARM WELDMENT |
| 1 | 1 | 1 | 1 | D2808 | SPACER |
| 1 | | | | D3560-1 | ARM |
| | 1 | | | D3560-2 | ARM |
| | | 1 | | D3560-3 | ARM |
| | | | 1 | D3560-4 | ARM |
| 1 | 1 | 1 | 1 | D3592-1 | PLATE |

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

| | | | |
|------------|---|---|--------------|
| D | ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS | DC | 07.11.16 |
| C | REMOVE POWDER COAT | CP | 07.06.19 |
| B | REDESIGN AS WELDMENT, ADD POCKETS | CP | 07.01.15 |
| A | NEW ISSUE | CP | 06.09.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 19P | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | 19C | | |
| CHECKED | 19P | DRAWING NO. | REV. D |
| MFG. APPR. | 19P | D3560 | SHEET 1 OF 5 |
| APPROVED | 19P | TITLE | SCALE |
| DE APPR. | 19P | ARM WELDMENT | 1:4 |
| DATE | 07.11.16 | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

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